

FIG.1

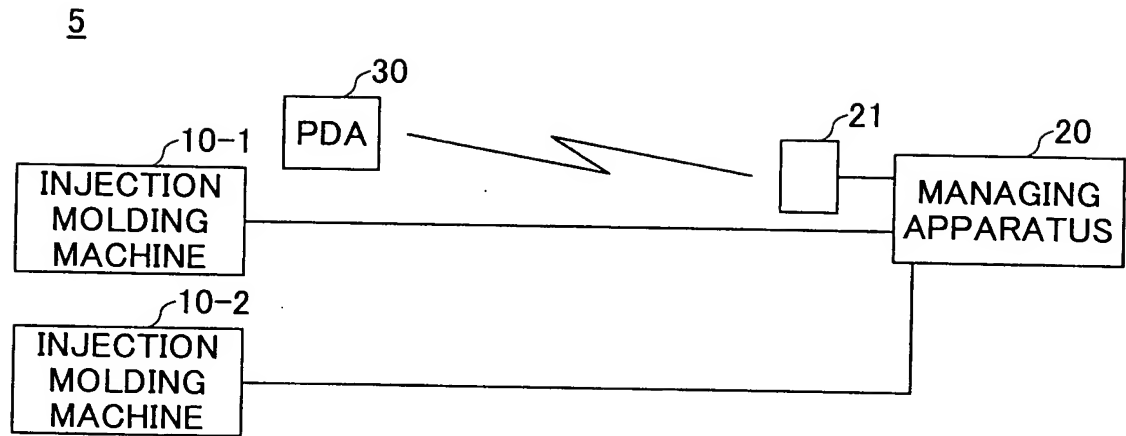


FIG.2

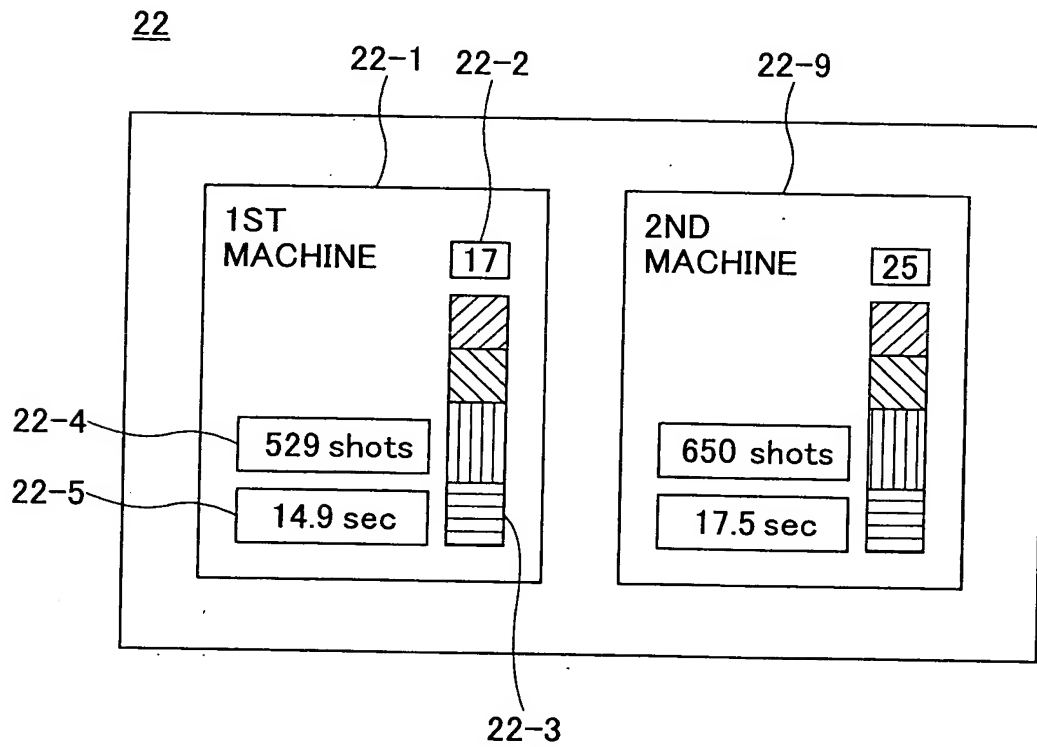


FIG.3

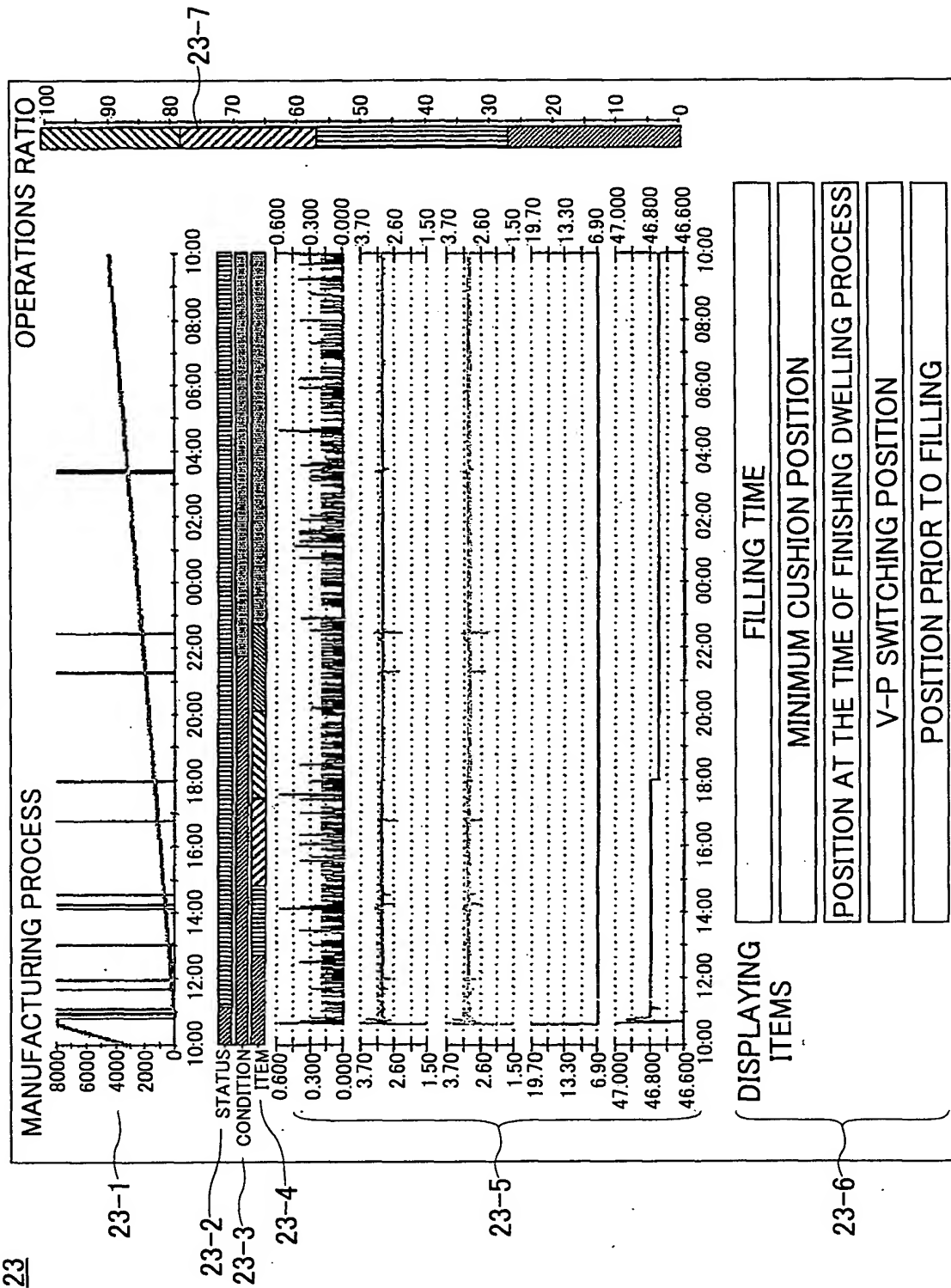


FIG.4

24

1ST MACHINE			
	24-1	24-2	24-3
			24-4
ITEMS	BEFORE CHANGED	AFTER CHANGED	DATE AND TIME
METERING FINISHING POSITION	46.25	46.20	2003/06/05 14:15:20
CYCLE MONITOR MODE	0	1	2003/06/05 10:20:15
MOLD PROTECTION MONITOR MODE	0	1	2003/06/05 10:20:15
MAXIMUM CUSHION MONITOR MODE	0	1	2003/06/05 10:20:15
MINIMUM CUSHION MONITOR MODE	0	1	2003/06/05 10:20:15

FIG.5

25

1ST MACHINE		
ITEMS	TIME OF OCCURRENCE OF ABNORMALITY	TIME OF LIFTING OF ABNORMALITY
[ABNORMALITY] MOLD PROTECTION	2003/06/01 10:20:15	2003/06/02 14:15:10
[INTER ROCK] SAFETY DOOR OPEN	2003/06/01 10:20:15	2003/06/02 14:15:10
[INTER ROCK] NOT FINISHED MOLD CLAMPING ADJUSTMENT	2003/06/01 10:20:15	2003/06/02 14:15:10

FIG.6

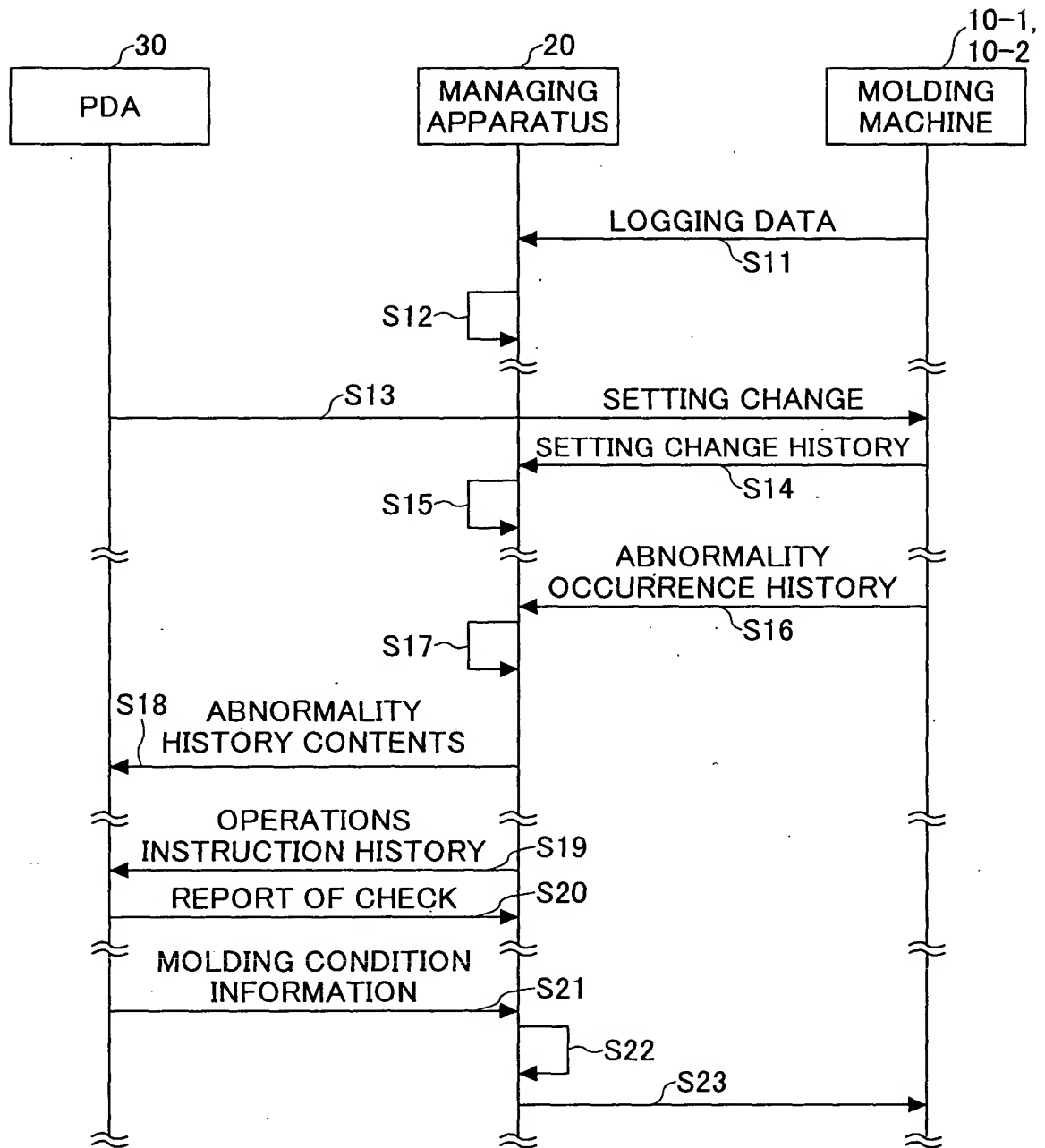


FIG.7

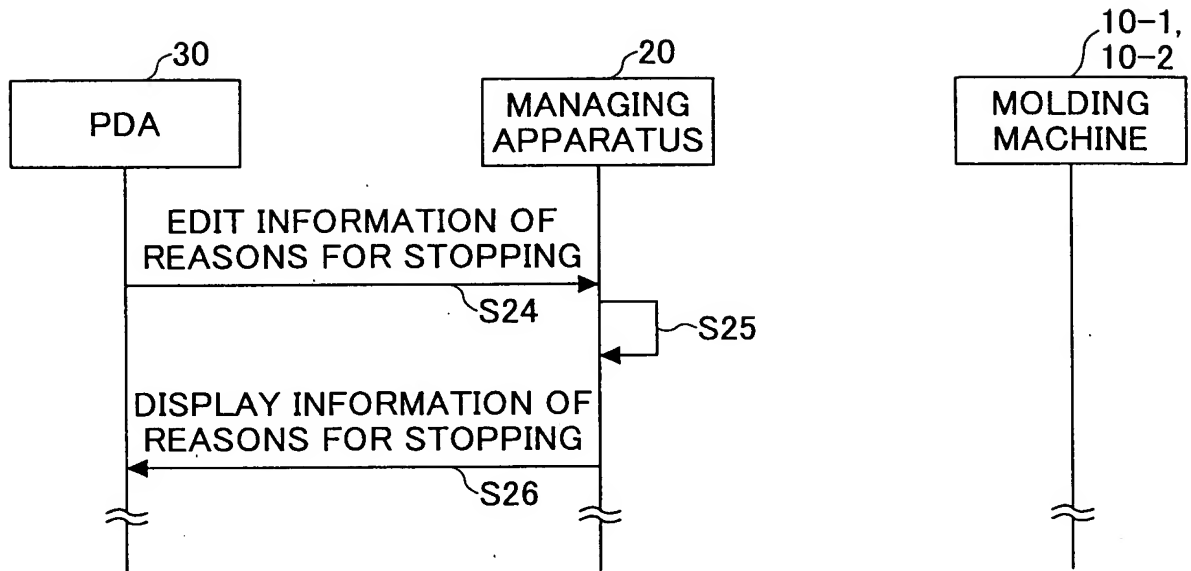
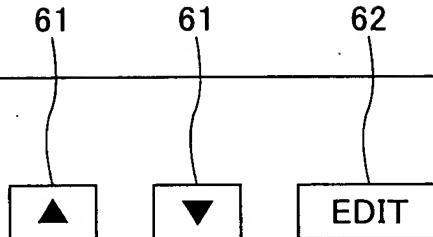


FIG.8

60



1ST MACHINE			
MOLDING CONDITION		INITIAL	
STATUS	ABNORMALITY OCCURS	TIME OF STOPPING	000:01:15
OCCURRENCE TIME		03/05 11:06:09	
RESTART TIME		03/05 11:07:24	
ABNORMALITY		[A000]CYCLE	
SUPPLEMENT		MOLD PROTECTION ABNORMALITY	
PERIPHERAL APPARATUS		MOLD	
REASON		PIN IS BROKEN	
OPERATOR		x x x x	
MEMO		REPAIRABLE	

FIG.9

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		MANUFACTURING INSTRUCTION	
OPERATOR		x x x x	
1ST MACHINE		MOLDING MACHINE	
<div>▲ ▼</div>		EDIT	RETURN
PRODUCT		FLOWERPOT	
MOLDING CONDITION		FLOWERPOT AB	
MOLD		FLOWERPOT 001	
MATERIAL		PP	
ESTIMATED MANUFACTURED NUMBER		1000	

FIG.10

80

OPERATOR x x x x

81 — 1ST MACHINE ▼

82 — SELECT MENU

FIG.11

85

86

REGISTER		OPERATOR x x x x	
1ST MACHINE			
MOLDING CONDITION		INITIAL	
STATUS	ABNORMALITY OCCURS	TIME OF STOPPING	000:01:15
OCCURRENCE TIME		03/05 11:06:09	
RESTART TIME		03/05 11:07:24	
ABNORMALITY		[A000]CYCLE	
SUPPLEMENT		MOLD PROTECTION ABNORMALITY	▼
PERIPHERAL APPARATUS		MOLD	▼
REASON		PIN IS BROKEN	▼
MEMO		REPAIRABLE	